

Duplicate

Date: Thursday, 6/21/2007 8:27:50 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: REPLACEMENT WINDOW ASSEMBLY		
Job Number	: 32285		Part Number	: D3290041		
Estimate Number	: 11174		Drawing Number	: D3290 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/21/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 5/10/2007 Type : SMALL /MED FAB		Due Date	: 6/6/2007 Qty: 6 Um: Each		
Previous Run	: 28649					
Written By	:					
Checked & Approved By	:					
Comment	: Est. B 05.05.25 Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798 EC Est Rev:D Now on Waterjet 06-06-16 JLM					

Additional Product:

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet
		Comment: Qty.: 3.9375 sf(s)/Unit Total : 23.6250 sf(s) 5052-H32 .040 Sheet (M5052H32S040) Batch: <i>[Handwritten]</i>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3290 Dwg Rev: <i>[Signature]</i> Prog Rev: _____ 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 8:27:50 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 32285

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

2584 only in

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total : 39.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description Batch
1 D2126-0780 Locking Seal

B23077(1)

B32619 (5)

9.0 D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description
1 D3290-1 Window Frame

Batch
B27566 -

(5) B26932(1) -

10.0 D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch
1 D3290-3 Window

B29568 (4)

EJF 7/6/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/16/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 8:27:50 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 32285

Part Number: D3290041

Job Number:



Seq. #:	Machine Or Operation:	Description :
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3290 Clean D3290-041 and place in plastic wrap</p> <p>SAS 07/06/06 (6) SAS 07/06/06 (6)</p>
12.0	QC5	INSPECT WORK TO CURRENT STEP
		<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p>Jrca 26</p>
13.0	PACKAGING 1	PACKAGING RESOURCE #1
		<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: S1272</p> <p>EJS 07/06/27 (6)</p>
14.0	QC21	FINAL INSPECTION/W/O RELEASE
		<p>Comment: FINAL INSPECTION/W/O RELEASE</p> <p>7/07/06/27</p> <p>(6)</p>

Job Completion



U 07/06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

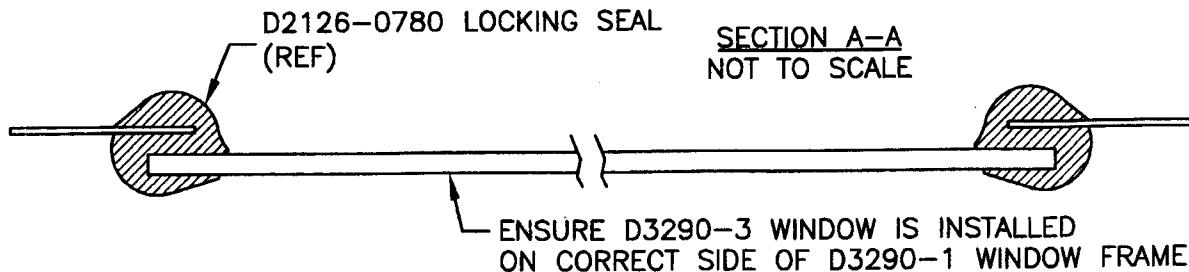
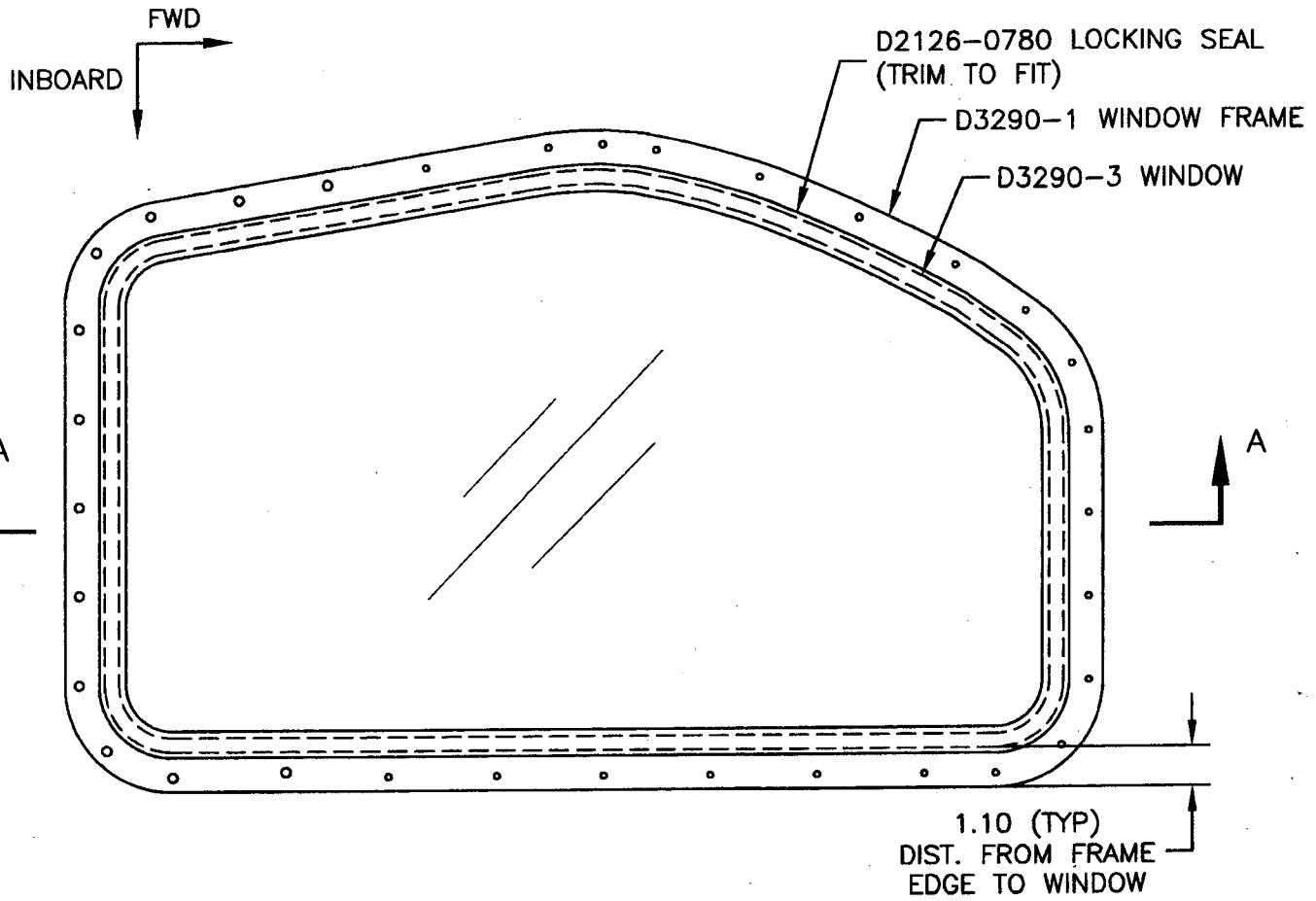
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 1 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
A	04.06.14	NEW ISSUE	
B	06.04.20	UPDATE MATERIAL PER NCR 029	

**D3290-041**

RELEASED

06.04.20 *[Signature]***NOTES**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

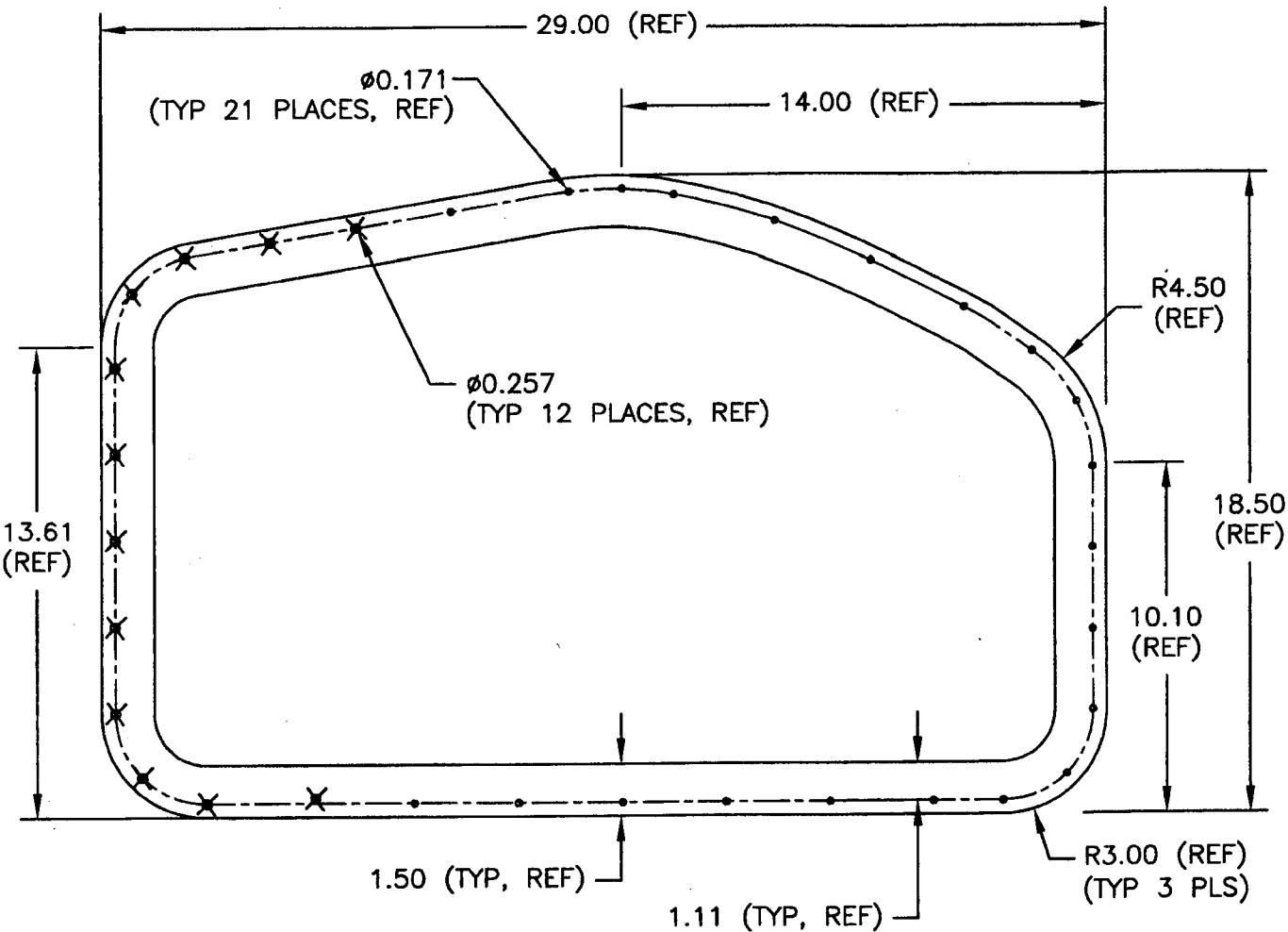
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

*CJ07/04/21
W/0 32285*

DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Initials]</i>	APPROVED <i>[Initials]</i>	DRAWING NO. D3290	REV. B SHEET 2 OF 3
DATE 06.04.20	TITLE REPLACEMENT WINDOW ASSEMBLY		SCALE 1:5

**D3290-1 FRAME****D3290-1**

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

06.04.20 *[Signature]*

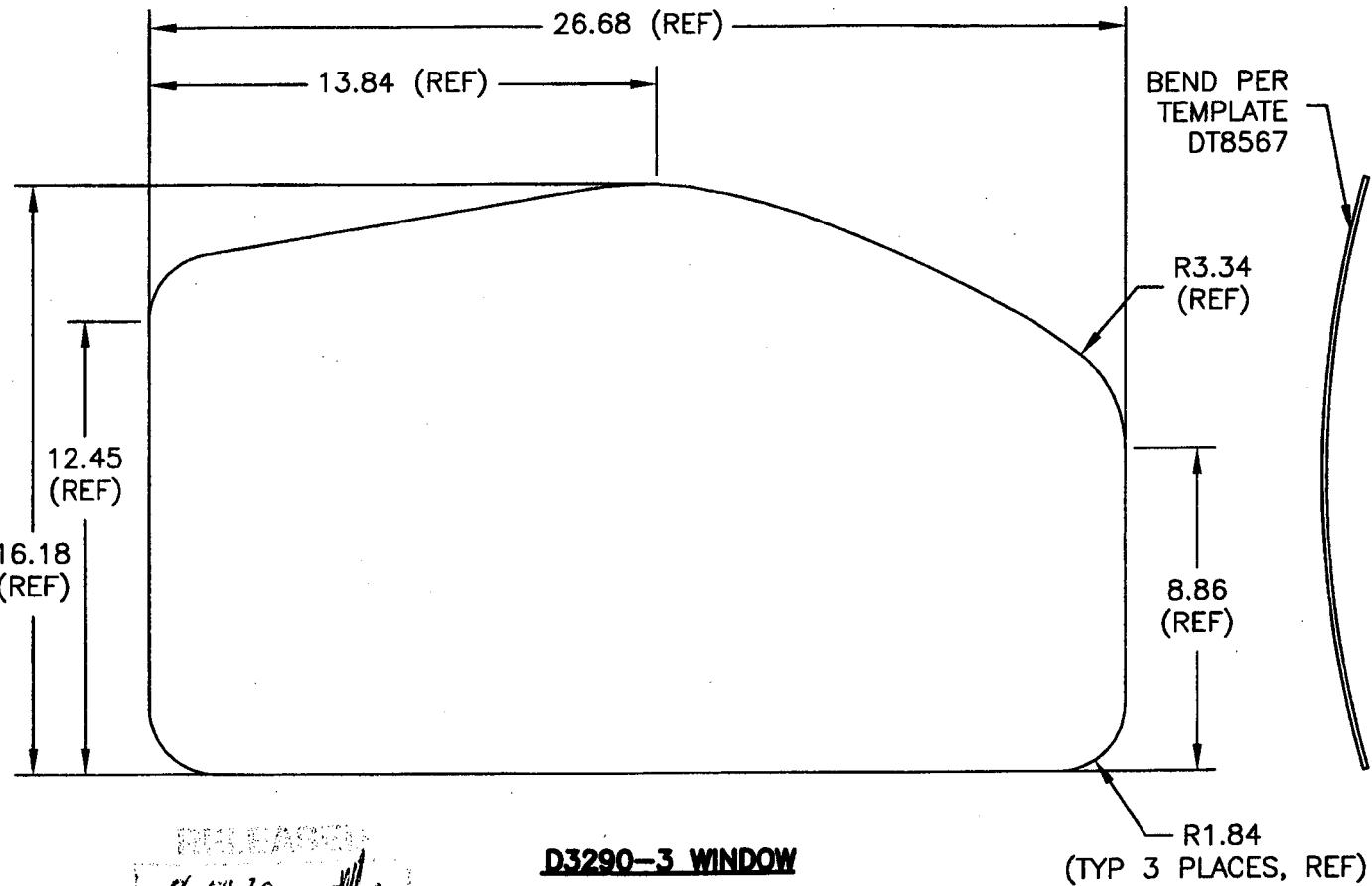
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

207/06/21
w/10 32285

DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 3 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5

**D3290-3**

- B**) 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) CHECK PART USING DT3290-3T1

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

0207/06/21
W/O 32285